

Work Order ID 117749

117749



Page 1

Thursday, May 01, 2014 10:36:27 AM

Item ID: D412-694-02

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-694	C1								

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Issue red decal labels for D412-694-02. CHG005

N/A MJS 14-12-23

Work Order ID 117749

Thursday, May 01, 2014 10:36:27 AM

117749

Page 2

Item ID: D412-694-02

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-02 Drill Process

1- D412-694-02 Drill Process Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-02 as per Dwg D412-694 page 4 (view P).

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c/sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). Note: D3151-041 orientation in the door.

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c/sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).

4- Drill Ø(#30) holes using drill Jig D3144-T7 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T8/-T9 as per Dwg D412-694 page 2.
Note: The (12) holes for the (6) nut plates cannot be less than 0.290" from inside edge.

5- Use unibit to open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-042 cover assembly as per Dwg D412-694 page 4 (view P).
Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-7. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

41 14-11-24

P40 →

Work Order ID 117749***117749***

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Thursday, May 01, 2014 10:36:27 AM

Item ID: D412-694-02

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 3/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-9 RH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø3/64" (0.578) for inserts.

9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-042 bracket. Use unibit to open holes to Ø3/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-042 cover.

120

0.00

120

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

1- Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors.

ET 14-11-24

DQA:

Date: 15/06/11



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/06/11

Work Order update only ☐

Work Order: <u>117749</u> Part No. <u>D412694-02</u> NCR No. <u>15-5084</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input checked="" type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14/11/26	110	x1	drill travelled off center of pilot hole in D3162-041 nut plate causing hole to be too oval shaped + hole to be in wrong location on inside of door h.c. operator + process	A.P. 14.11.27	Scrap + replace nut plate Fill improperly filled hole with hysol 934 allow to cure + re-drill hole in proper location MS21059L3 B730823	14-11-26	DAS 9 9-89 14-12-23	DAS 9 9-89 14-12-23
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input checked="" type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA:

Date:

15/06/11

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

15/06/11

Work Order update only ☐

Work Order: <u>117749</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D412-694-02</u>	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>	
NCR No. <u>15-5085</u>	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-11-25	180	+1	hole for D3110-5 door handle too close to fwd edge of door causing D3163-041 cover Assy to overhang the edge	DAS 12 9-89	use D3163-041 cover Assy installed offset in hole location compensates + lines up good	14-11-26	DAS 9 9-89	DAS 9 9-89
Doc/Data				D3151-041 installed backwards, DUG NOT CLEAR.		MECHANISM FUNCTIONS AND CLEARS ALL SURFACES	10/11/12	14-12-23	14-12-23
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input checked="" type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Set-up
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Work Order ID 117749

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117749

Page 4

Item ID: D412-694-02

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control	Inspect that inserts are flush with the surface.								DAS 9 9-89
140		0.00							
140	COMPOSITE ASSEMBLY								
Small Fab	Memo	0.00							
Small Fab	1. Apply Primer filler and reducer around the inserts on both doors.								
	A/R 11045 Primer Filler Batch: M130926								
	A/R 12375S Reducer Batch: M130926								
150	QC14- Inspect Spray Paint	0.00							
150									
QC	Memo	0.00							
Quality Control									DAS 9 9-89

① 14-12-23

14-11-28

(PTO) P

① 14-12-23

DQA: Aut Date: 15/06/11

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RPM Date: 15/06/11Work Order update only ☐

Work Order: <u>117749</u> Part No. <u>D412-694-02</u> NCR No. <u>15-5086</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input checked="" type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14-11-26	110	x3	80-005-2-8 inserts not seated properly R.C. process operator error	A.R. 14.11.26	drill out insert under cut with dremel. put new insert 80-005-2-8 B 129790 <div>x3</div>	<div>41</div> 14-11-26	<div>DAS 9 9-89</div> 14-12-23	<div>DAS 9 9-89</div> 14-12-23
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator	X									
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input checked="" type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA:

Date: 15/06/11

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>117749</u>	DISPOSITION <input checked="" type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab </div> <div> <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite </div> <div> <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier </div> <div> <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other </div> </div>			
Part No. <u>DY12-69402</u>					
NCR No. _____					

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14-12-23	10	x2	MS 51859-7 plate id too small hard to open up id make Design is being change	A.P. 14.12.23	use MS 51859-8 turn down O.D. using OT 10079 on manual lathe to 0.710" MS 51859-8 B 127993 x2	2T 14-12-23	DAS 9 9-89 14-12-23	DAS 9 9-89 14-12-23
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Set-up
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Work Order ID 117749

Thursday, May 01, 2014 10:36:27 AM

117749

Page 5

Item ID: D412-694-02

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-02 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-043/-044.

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-042 Rod Weldment with D3122-1 Lever and D3133-042 Rod Weldment as per Dwg D412-694 page 4 (view P).

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

 14-12-01

Work Order ID 117749

117749

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Thursday, May 01, 2014 10:36:27 AM

Item ID: D412-694-02

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

① 12-23

DAS
9
9-88

Work Order ID 117749***117749***

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Thursday, May 01, 2014 10:36:27 AM

Item ID: D412-694-02

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-02 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-042 Cover Assembly. Ensure Handle works freely. Ensure D3163-042 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes are around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

4- Open 15/64" (0.234) holes to D3163-042 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-4 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

A/R RTV732 Clear Batch: M 130290 Expiry:15-06-01

7- Install D3126 Brackets and D3138-2 Cover as per Dwg D412-694 page 2

ZFT 14-12-01

Work Order ID 117749

117749

Page 8

Thursday, May 01, 2014 10:36:27 AM

Item ID: D412-694-02

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Assembly, RH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

(view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

014223

DAS
9
9-89

200

COMPOSITE ASSEMBLY

0.00

200

Small Fab

Memo

0.00

Small Fab

1- Finish installing D3163-042 in the door.
2- Install red decal before closing cover.

DAS
38
9-89

14-12-07

Work Order ID 117749***117749***

Page 9

Thursday, May 01, 2014 10:36:27 AM

Item ID: D412-694-02 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Assembly, RH
Start Date: 5/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/22/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Install door on mock up helicopter to insure proper fit and	0.00 0.00	POSITIVE RECALL EFFECTIVE RELEASED		AUTH DATE		① 14-12-23		DAS 9 200
220 *220* Packaging Packaging	Identify as per dwg & Stock Location: <u>CA2</u> Memo	0.00 0.00	NA				14-12-23		
230 *230* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				ML5	14-12-24		ML5 14-12-23

Picklist Print

Thursday, May 01, 2014 10:36:20 AM

Page 1

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 05.12.09 New Issue KJ/RF
IPP Rev B 06.04.18 New dwg rev. ecn781 EC
IPP Rev:C 06.07.10 Revised per B24659 KJ
IPP Rev:D 08-08-27 replace QC5 to QC14 seq.7 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

80-005-2-8		Purchased	No			160	Each	270.0000	55	55			
										**	M129790	DAS	
												06	
												9-89	

Insert

Location	Loc Qty	Loc Code
ST380	270	
113109	23	
120273	47	
121500	100	
122661	100	

AN525-10R6		Purchased	No			160	Each	96.0000	12	12			
										**	M120 325	DAS	
												06	
												9-89	

Screw

Location	Loc Qty	Loc Code
ST344	96	
M127743	96	

AN525-10R7		Purchased	No			160	Each	1,465.000	8	8			
										**			

SCREW

Location	Loc Qty	Loc Code
ST344	2	
m127447	2	
ST505	1463	
m127815	713	
m128429	750	

NOV 08 2014

DAS
06
9-89

8

Picklist Print

Thursday, May 01, 2014 10:36:20 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

BSP45 Purchased No 160 Each 477.0000 79 79

RSP45

Commercial Rivet

130851 x 8 **

130741 x 71

SL

Location Loc Qty Loc Code

ST282 477

120417 477

BSP46 Purchased No 160 Each 251.0000 6 6

RSP46

Commercial rivet

**

DAS
06
9-89

Location Loc Qty Loc Code

ST282 251

112540 251

D3110-5 Manufactured No 160 Each 1.0000 1 1

D3110-5

Handle Assembly

**

124321

DAS
06
9-89

Location Loc Qty Loc Code

ST026 1

83229 1

D3115-1 Manufactured No 160 Each 2.0000 1 1

D3115-1

Bracket

**

123113

24

Location Loc Qty Loc Code

ST026 2

82774 2

D3116-7 Manufactured No 160 f 485.0000 5.6666 6

D3116-7

Seal(\$Per Foot)

**

14.11-24

14-11-8

Location Loc Qty Loc Code

ST414A 485

65117 485

16

Picklist Print

Thursday, May 01, 2014 10:36:20 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3116-9 Manufactured No 160 f 550.0000 6.4166 7

D3116-9

Seal (\$Per Foot)

**

DAS
06
3-89

Location Loc Qty Loc Code

ST414A 550

39182 550

D3121-041 Manufactured No 160 Each 3.0000 3 3

D3121-041

Bracket Assembly

**

124359

DAS
06
3-89

Location Loc Qty Loc Code

ST235 3

101711 3

D3121-044 Manufactured No 160 Each 2.0000 1 1

D3121-044

Bracket Assembly

**

28718

DAS
06
3-89

Location Loc Qty Loc Code

ST235 2

110661 2

D3122-1 Manufactured No 160 Each 3.0000 1 1

D3122-1

Lever

**

122930

DAS
06
3-89

Location Loc Qty Loc Code

ST027 3

65171 3

D3123-1 Manufactured No 160 Each 212.0000 2 2

D3123-1

Cam Assembly

**

14-11-24

14-11-8

Location Loc Qty Loc Code

Mezz 212

1053617 212

272

Picklist Print

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Thursday, May 01, 2014 10:36:20 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3124-1 Manufactured No 160 Each 80.0000 1 1

D3124-1

Hook

**

14 11-24

Location Loc Qty Loc Code

CA 80

1053617 80

D3124-2 Manufactured No 160 Each 75.0000 1 1

D3124-2

Hook

**

Location Loc Qty Loc Code

ST027 75

1053617 75

D3126-1 Manufactured No 160 Each 10.0000 1 1

D3126-1

Bracket

**

Location Loc Qty Loc Code

ST027 10

105268 10

D3126-3 Manufactured No 160 Each 0.0000 1 1

D3126-3

Bracket

**

①

B113689 SP

D3126-5 Manufactured No 160 Each 2.0000 5 5

D3126-5

Bracket

**

⑤

B124451 SP
14-11-8

Location Loc Qty Loc Code

CA 1

36729 1

ST027 1

113560 1

Picklist Print

Page 5

Thursday, May 01, 2014 10:36:20 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3132-042 Manufactured No 160 Each 30.0000 1 1

D3132-042

Rod Weldment

**

2ET 14-11-24

Location

Loc Qty

Loc Code

Mezz

30

1053617

30

D3133-041 Manufactured No 160 Each 14.0000 1 1

D3133-041

Rod Weldment

**

2ET 14-11-24

Location

Loc Qty

Loc Code

CA

14

1053617

14

D3135-041 Manufactured No 160 Each 2.0000 1 1

D3135-041

Handle Weldment

**

1 B123060 sp

Location

Loc Qty

Loc Code

ST236B

2

78748

2

D3137-045 Manufactured No 160 Each 3.0000 1 1

D3137-045

Bracket Assembly

**

1 B124403.52

Location

Loc Qty

Loc Code

ST235B

3

80099

3

D3138-2 Manufactured No 160 Each 1.0000 1 1

D3138-2

Cover

**

2 14-11-24

Location

Loc Qty

Loc Code

ST241A

1

50584

1

14-11-8

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Shop Packet Print

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Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3139-1 Manufactured No

160 Each

1.0000

1

D3139-1

**

Guard

Location

Loc Qty

Loc Code

ST027

1

109457

1

D3139-4 Manufactured No

160 Each

7.0000

1

D3139-4

**

Guard

Location

Loc Qty

Loc Code

CA

3

24700

3

ST027

4

63961

4

D3140-06 Manufactured No

160 Each

1.0000

1

D3140-06

**

Door

Location

Loc Qty

Loc Code

CA

1

78941

1

D3141-1 Manufactured No

160 Each

4.0000

2

D3141-1

**

Spring

Location

Loc Qty

Loc Code

ST028

4

63507

4

D3144-111 Manufactured No

160 Each

0.0000

1

D3144-111

**

Doubler

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Shop Packet Print

Page 6

B110721 SP.

SP.

117734
SP 14-10-22

B123037. SP

SP 14-11-24 14-11-24

B78710

Picklist Print

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Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3144-115 Manufactured No

160

Each

1.0000

1

1

D3144-115

Doubler

B 126006

**

ET 14-11-24

Location

Loc Qty

Loc Code

CA

1

22021

1

D3144-123 Manufactured No

160

Each

2.0000

1

1

D3144-123

Doubler

B 124121

**

ET 14-11-24

Location

Loc Qty

Loc Code

CA

2

78761

2

D3144-13 Manufactured No

160

Each

3.0000

1

1

D3144-13

Doubler

,

**

ET 14-11-24

Location

Loc Qty

Loc Code

CA

3

67799

3

D3148-1 Manufactured No

160

Each

172.0000

2

2

D3148-1

Clevis

**

ET 14-11-20

Location

Loc Qty

Loc Code

Mezz

172

1053617

172

D3151-041 Manufactured No

160

Each

8.0000

1

1

D3151-041

Doubler Assembly

B 50294

**

ET 14-11-24

14-11-8

Location

Loc Qty

Loc Code

CA

8

39186

8

Picklist Print

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Thursday, May 01, 2014 10:36:22 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3152-042	Manufactured	No	160	Each	0.0000	1	(1)
D3152-042						**	B 120133 SP
Bracket Assembly							

D3155-041	Manufactured	No	160	Each	7.0000	1	1
D3155-041						**	SP
Bracket Assy							

Location	Loc Qty	Loc Code
ST030	7	
53041	7	
	160	Each 3.0000

D3155-042	Manufactured	No	160	Each	3.0000	1	1
D3155-042						**	IX 14-11-24
Bracket Assy							

Location	Loc Qty	Loc Code
ST030	3	
94605	1	
b56141	2	
	160	Each 3.0000

D3156-1	Manufactured	No	160	Each	3.0000	2	2
D3156-1						**	B110756 SP
Bracket							

Location	Loc Qty	Loc Code
ST030	3	
50297	3	
	160	Each 0.0000

D3162-041	Manufactured	No	160	Each	0.0000	10	10
D3162-041						**	B110680 SP 14-11-8
Bracket Assembly							

Picklist Print

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Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3203-1 Manufactured No 160 Each 33.0000 1 1

D3203-1

Handle

SP

Location	Loc Qty	Loc Code
ST240	33	
108749	20	
109418	10	
89124	3	

1X

D3308-1

Manufactured No 160 Each 5.0000 2

D3308-1

Doubler

2 B123054 SP

Location	Loc Qty	Loc Code
ST037	5	
78712	5	

M7885/2-4-3

Purchased No 160 Each 413.0000 12 12

M7885/2-4-3

Rivet

SP

Location	Loc Qty	Loc Code
ST287	413	
107376	413	

12x

M7885/3-4-4

Purchased No 160 Each 108.0000 12 12

M7885/3-4-4

Rivets

4-11-8 SP

Location	Loc Qty	Loc Code
ST287	108	
108077	108	

12x

Picklist Print

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Thursday, May 01, 2014 10:36:25 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS20392-2C17

Purchased

No

160

Each

173.0000

2

2

MS20392-2C17

**

PIN

Location

Loc Qty

Loc Code

ST333

173

18949

173

MS20392-2C9

Purchased

No

160

Each

8.0000

2

2

MS20392-2C9

**

Pin

Location

Loc Qty

Loc Code

ST333

8

11784

5

120521

3

MS20392-3C21

Purchased

No

160

Each

16.0000

2

2

MS20392-3C21

**

PIN

Location

Loc Qty

Loc Code

ST333

16

124296

16

MS20426AD3-3

Purchased

No

160

Each

6,262.000

8

8

MS20426AD3-3

**

RIVET

Location

Loc Qty

Loc Code

ST334

428

123352

428

ST553

5834

M128754

5834

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Picklist Print

Thursday, May 01, 2014 10:36:25 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

160

Each

1,207.000

4

4

MS20426AD4-5

SP

RIVET

Location

Loc Qty

Loc Code

ST334

1207

6874

207

m125807

1000

MS20426AD4-6

Purchased

No

160

Each

2,941.000

4

4

MS20426AD4-6

SP

Rivet

Location

Loc Qty

Loc Code

MF4

102

124392

102

ST334

952

124392

952

ST336

1887

M128812

1887

MS21042L08

Purchased

No

160

Each

5,857.000

6

6

MS21042L08

SP
14-11-8

Nut

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2200

125445

802

m127410

1398

ST509

99

m127304

99

Picklist Print

Thursday, May 01, 2014 10:36:26 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

160

Each

7,800.000

4

MS21042L 4

Locknut

**

4

m122934 sp

Location

Loc Qty

Loc Code

ST314

64

m126015

12

m126275

52

ST509

7725

m127255

71

m127813

994

m128300

1660

m128798

5000

ST518

11

m127376

11

MS21072-L3

Purchased

No

160

Each

230.0000

4

MS21072-L 3

Nutplate

**

4

sp

Location

Loc Qty

Loc Code

ST318

230

121047

20

125535

210

4x

MS24665-151

Purchased

No

160

Each

424.0000

6

MS24665-151

Cotter Pin

**

6

sp

14-11-8

Location

Loc Qty

Loc Code

GA

24

17566

24

ST323

400

m128401

400

6x

Picklist Print

Thursday, May 01, 2014 10:36:26 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS24693-S271

Purchased

No

160

Each

563.0000

4

4

MS24693-S271

Screw

SP

Location

Loc Qty

Loc Code

ST301

563

14478

563

4x

MS24694-C5

Purchased

No

160

Each

36.0000

4

4

MS24694-C5

Screw

SP

Location

Loc Qty

Loc Code

ST300

36

106815

36

4

MS24694-S5

Purchased

No

160

Each

385.0000

6

6

MS24694-S5

Screw

SP

Location

Loc Qty

Loc Code

ST302

385

18949

44

19073

341

6A

MS24694-S50

Purchased

No

160

Each

594.0000

18

MS24694-S50

Screw

18 m130358 SP
14-11-8

Location

Loc Qty

Loc Code

ST302

576

m128401

76

m129022

500

ST303

18

m127831

18

Picklist Print

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Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS24694-S98

Purchased

No

160

Each

136.0000

4

4

MS24694-S98

Screw

SP

Location

Loc Qty

Loc Code

ST303

136

125578

26

m128228

10

m128606

100

MS27039-1-05

Purchased

No

160

Each

42.0000

2

2

MS27039-1-05

SCREW

SP

Location

Loc Qty

Loc Code

ST305

42

124555

42

MS27039-1-06

Purchased

No

160

Each

803.0000

14

14

MS27039-1-06

Screw

SP

Location

Loc Qty

Loc Code

ST305

803

104289

803

MS27039-1-08

Purchased

No

160

Each

2,111.000

13

13

MS27039-1-08

Screw

14-14-8 SP

Location

Loc Qty

Loc Code

GA

19

m125654

19

ST305

2092

m128636

2092

13x

Picklist Print

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Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS35275-233

Purchased

No

160

Each

63.0000

2

2

MS35275-233

Screw

Location

Loc Qty

Loc Code

ST289A

63

103641

20

11822

43

MS35649-264

Purchased

No

160

Each

53.0000

2

2

MS35649-264

Nut

Location

Loc Qty

Loc Code

ST289A

53

11822

53

MS35650-3252

Purchased

No

160

Each

34.0000

2

2

MS35650-3252

Nut

Location

Loc Qty

Loc Code

ST289A

34

110372

34

MS51859-7

Purchased

No

160

Each

75.0000

3

MS51859-7

Washer

Location

Loc Qty

Loc Code

ST290

75

123482

8

M127993

67

-9

14-11-8

Picklist Print

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Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0316J

Purchased

No

160

Each

1,048.000

15

15

NAS1149D0316.I

**

Washer

SP

Location

Loc Qty

Loc Code

ST293

648

M127993

648

ST510a

400

M127956

400

15x

NAS1149D0332J

Purchased

No

160

Each

5,569.000

18

18

NAS1149D0332.I

**

Washer

SP

Location

Loc Qty

Loc Code

ST294

569

m128606

569

ST510a

5000

m128612

5000

18x

NAS1149D0416J

Purchased

No

160

Each

494.0000

6

6

NAS1149D0416.I

**

WASHER

SP

14-11-8

Location

Loc Qty

Loc Code

GA

119

m126254

119

ST293

300

m129022

300

ST294

75

m125773

11

m127832

64

1x

1x

1x

Picklist Print

Thursday, May 01, 2014 10:36:26 AM

Work Order ID: 117749

117749

Parent Item: D412-694-02

D412-694-02

Parent Item Name: Door Assembly, RH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

160

Each

3,062.000

6

6

NAS1149DN832.J

Washer

**

SP

Location

Loc Qty

Loc Code

MF4

808

M127255

808

ST293

2092

M128948

1000

M127813

92

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

6x

NAS43DD3-10

Purchased

No

160

Each

47.0000

7

7

NAS43DD3-10

SPACER

**

SP

Location

Loc Qty

Loc Code

ST275

47

19185

9

19347

38

7x

NAS43DD3-14

Purchased

No

120

Each

76.0000

6

6

NAS43DD3-14

Spacer

**

14/11-8

SP

Location

Loc Qty

Loc Code

ST275

76

113368

40

19347

36

6x